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DART AEROSPACE LTD		Work Order:	19349
Description: Bearpaw Kit (19" x 24")		Part Number:	K10008
Dwg: D2432 Rev. F3		Qty:	15 Kits
Ref: K10008 Rev. E		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	RF	03.06.17	15																																																
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 <b>(Bag Bluefiles separately)</b>	FOL KJ	WK 27 RF	03.06.17 15																																																
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 20.00" x 24.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10)	SG	03.06.18	15																																																
4	MV	Inspect material for defects or damage prior to machining	SP	03.06.18																																																	
5	MV	Machine as per Folio D2432 and Dwg D2432	SP	03.06.18																																																	
6	QC2	Inspect parts as they come off the CNC machine	SP	03.06.18																																																	
7	MV	Deburr	SP	03.06.18																																																	
8	QC8 & 5	Second inspection	E	03.06.18																																																	
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>6</td> <td>D2182B050</td> <td>Rubber Cushion</td> <td>A18914</td> </tr> <tr> <td>12</td> <td>D2274</td> <td>Radius Block</td> <td>B18971</td> </tr> <tr> <td>2</td> <td>D2432F</td> <td>24" Bearpaw</td> <td>B19349</td> </tr> <tr> <td>6</td> <td>D2438</td> <td>Clamp</td> <td>B18965</td> </tr> <tr> <td>12</td> <td>D2529</td> <td>Washer</td> <td>B18529</td> </tr> <tr> <td>6</td> <td>D2732-050</td> <td>Rubber Cushion</td> <td>B18970</td> </tr> <tr> <td>12</td> <td>AN4-15A</td> <td>Bolt M13437</td> <td>M12903</td> </tr> <tr> <td>12</td> <td>AN4-17A</td> <td>Bolt M12092</td> <td>M11045</td> </tr> <tr> <td>24</td> <td>AN960JD416</td> <td>Washer</td> <td>M12749</td> </tr> <tr> <td>12</td> <td>MS21042L4</td> <td>Nut (or -4)</td> <td>M12X020</td> </tr> <tr> <td>1</td> <td>Paperwork package from Step 2</td> <td></td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	A18914	12	D2274	Radius Block	B18971	2	D2432F	24" Bearpaw	B19349	6	D2438	Clamp	B18965	12	D2529	Washer	B18529	6	D2732-050	Rubber Cushion	B18970	12	AN4-15A	Bolt M13437	M12903	12	AN4-17A	Bolt M12092	M11045	24	AN960JD416	Washer	M12749	12	MS21042L4	Nut (or -4)	M12X020	1	Paperwork package from Step 2			①	03.06.24	15
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10	QC4	Inspect Kit for 100% Completeness on the W/O	SP	03.06.20	15																																																
11	PK	Identify and pack for shipping as per PPP K10008 REV. E	① SP	03.06.26	15																																																
12	AC	Cost / part ZZZ58	SG	03.06.27	15																																																
13	DC	Close W/O ZZZ7.62 Inspect Level 21 BB	SP	03.06.27	15																																																

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	RF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyJun 16, 2003  
02:42 pm

Work Order No : 0019349  
 Project Name : \*K10008  
 Project For : WK329  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : \*K10008  
 Description : Bearpaw kit 19" x 24"  
 Manufactured : Yes  
 Amount Req'd : 15  
 Amount Done : 0  
 Start Date : 06-16-03  
 Est Finish Date : 07-15-03  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Testing Hours	0.00	0.00	0.00		
Testing Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
SubContract Hours	0.00	0.00	0.00		
SubContract	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour-Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



**Dart Aerospace, Ltd**  
1270 Aberdeen Street  
Hawkesbury, Ontario  
K6A 1K7  
Tel: (613) 632-3336 Fax: (613) 632-4443

**Supplier Code:** \_\_\_\_\_ **Sheet** \_\_\_\_ of \_\_\_\_

## INSPECTION CHECKLIST

PART NO.: 14930

PHY. CHANGE: \_\_\_\_\_

DESCRIPTION: Bennett

DRAWING CHANGE: *ZEV.F*

MANUFACTURING DATE: 03/16/18

## UNICORP F.O.'S:

BATCH NO.:

SERIAL NO.:

PURCHASE ORDER NO.:

QUANTITY ACCPT. REJ.

**DATA SHEET NO.:**

FIRST ARTICLE     PERIODIC CONFORMITY     FINAL INSPECTION

ITEM	DWG PAGE	DRAWING DIMENSION	TOL.	ACTUAL DIMENSION	ACC.	REJ.	% OF INSP.	Method of Inspection	Comments
1	1	19.000 ±0.10	.100	19.000	✓		100%	G	
1	1	.30 ±0.00	.000	.300	✓				
1	1	.30 ±0.00	.000	.300	✓			D-MIC	
1	1	.93 ±0.00	.000	.930	✓			DEVM	
1	1	.33 ±0.00	.000	.330	✓			H-G	
1	1	.375 ±0.00	.000	.375	✓			DEVM	
1	1	.375 ±0.00	.000	.375	✓			"	
1	1	7.375 ±0.00	.000	7.375	✓				
1	1	11.625 ±0.00	.000	11.625	✓			"	
1	1	2.000 ±0.00	.000	2.000	✓			"	
1	1	2.375 ±0.00	.000	2.375	✓			R-G	
1	1	2.500 ±0.00	.000	2.500	✓			"	
1	1	11.000 ±0.00	.000	11.000	✓			DEVM	
1	1	20.000 ±0.00	.000	20.000	✓			H-G	
<hr/>									
1	1	.063 ±0.10	.063	.063	✓			DEVM	
1	1	.5500 ±0.00	.000	.5500	✓			"	
1	1	.200 ±0.00	.000	.195	✓			D-MIC	
1	1	.20 ±0.00	.000	.200	✓			DEVM	
<hr/>									
1	1	.375 ±0.10	.375	.375	✓			MIC	
1	1	.950 ±0.00	.950	.950	✓			"	
1	1	.250 ±0.00	.250	.249	✓			"	

Mesured by: 

Audited by: 

Approved by: 